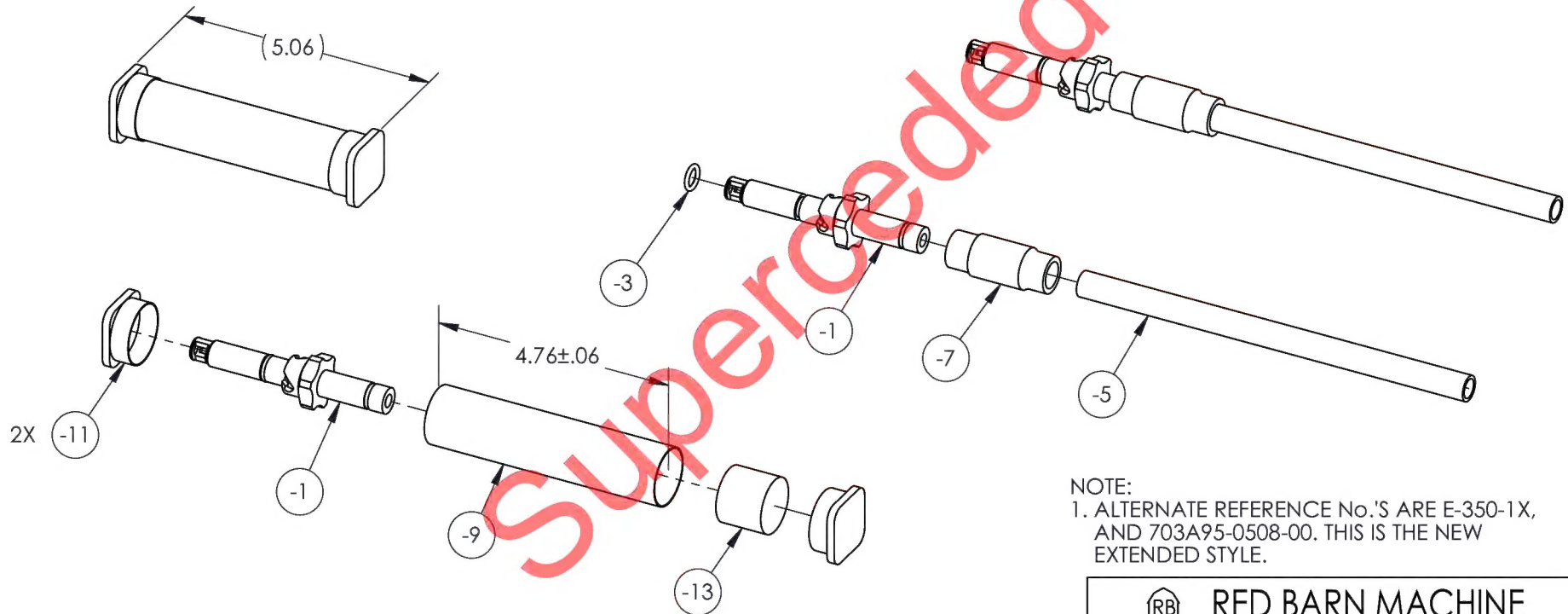


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UNDER REVIEW
URF 19-563 19.02.05 (KPT)

REVISIONS			
REV	DESCRIPTION	DATE	INITIAL
1	CH'D O-RING FROM Ø13mm OD x 1.75mm cross section. ADDED NOTES, CH'D SLOTS FROM 90°@ Ø.131, AND ID FROM Ø.230	5/28/2009	WP
2	CH'D ID FROM Ø.256 THRU, CH'D SLOTS FROM 60°@ Ø.125 ON HELIX PER G.E.	11/4/2009	RJC
2A	DELETED 20.2° REF. DIMENSION PER G.E.	12/16/2010	RJC
3	MODIFIED -1 TO WORK WITH COUPLING, ADDED COUPLING, TUBE, CAPS, AND SPONGE, DELETED HOSE CLAMP.	1/7/2013	JAG
4	CH'D 8X R.156 & 8X .12 TO 6X R.375 & 6X .106.	4/17/2013	CFS
5	CH'D T/N WAS RBEA95-0508-00 IS RBE703A95-0508-00. -1 CH'D DIMS WAS 6X .106 IS 6X .11, WAS 6X R .375 IS 6X R .38.	6/19/2013	BIM
5A	CH'D TOOL NAME WAS MAIN GEAR BOX DRAIN TOOL IS MGB DRAIN TUBE.	11/7/2013	RJC
5B	-9 CH'D DIM WAS 4.86 IS 4.76. -13 CH'D MATERIAL TO NEW PIG CORP. #PAD210.	2/5/2014	DPD
5C	-5 CH'D LENGTH OF HOSE WAS 6 FEET IS 7 FEET.	3/26/2014	RJC

SEE ATTACHED DEVIATION



NOTE:
1. ALTERNATE REFERENCE No.'S ARE E-350-1X, AND 703A95-0508-00. THIS IS THE NEW EXTENDED STYLE.

ASSY QTY	ASSY QTY	B/O	Part #	UNIT QTY	Description	Material	B/O INFORMATION OR SPECIFICATIONS	PG.
			-1	1	QUILL	6061	Ø1-1/8 X 4-1/8	2
		B/O	-3	1	O-RING	VITON	Ø13mm O.D. x 2mm WIDTH MCMaster-CARR #9263K173	1
		B/O	-5	1	HOSE	VINYL	Ø1/2 O.D. x Ø3/8 I.D. x 7ft KURI-TECH #K010-0608	1
		B/O	-7	1	COUPLING	NICKEL-PLATED BRASS	Ø1/2 MCMaster-CARR #51495K116	1
		B/O	-9	1	TUBE	POLYETHYLENE	Ø1.09 MCMaster-CARR #2044T47	1
		B/O	-11	2	CAP	VINYL	Ø1.09 MCMaster-CARR #2044T67	1
		B/O	-13	1	SPONGE	POLYESTER/POLYURETHANE	Ø1.09 X 1 NEW PIG CORP. #PAD210	1

RED BARN MACHINE	
TITLE MGB DRAIN TUBE	
DWG NO. RBE703A95-0508-00	REV 5C
MAT'L UNLESS OTHERWISE SPECIFIED DIMENSIONS ARE IN INCHES .XXX ± .005 FRACTIONS ± 1/32 .XX ± .01 ANGLES ± 5° .X ± .1	
DRAWN BY: PERRITT	
APPROVED D Weil	
HEAT TREAT	
FINISH	
SPEC	
USED ON MODEL AS350, EC130	
SCALE 1:3	DATE 7/31/2012
SHEET 1 OF 2	

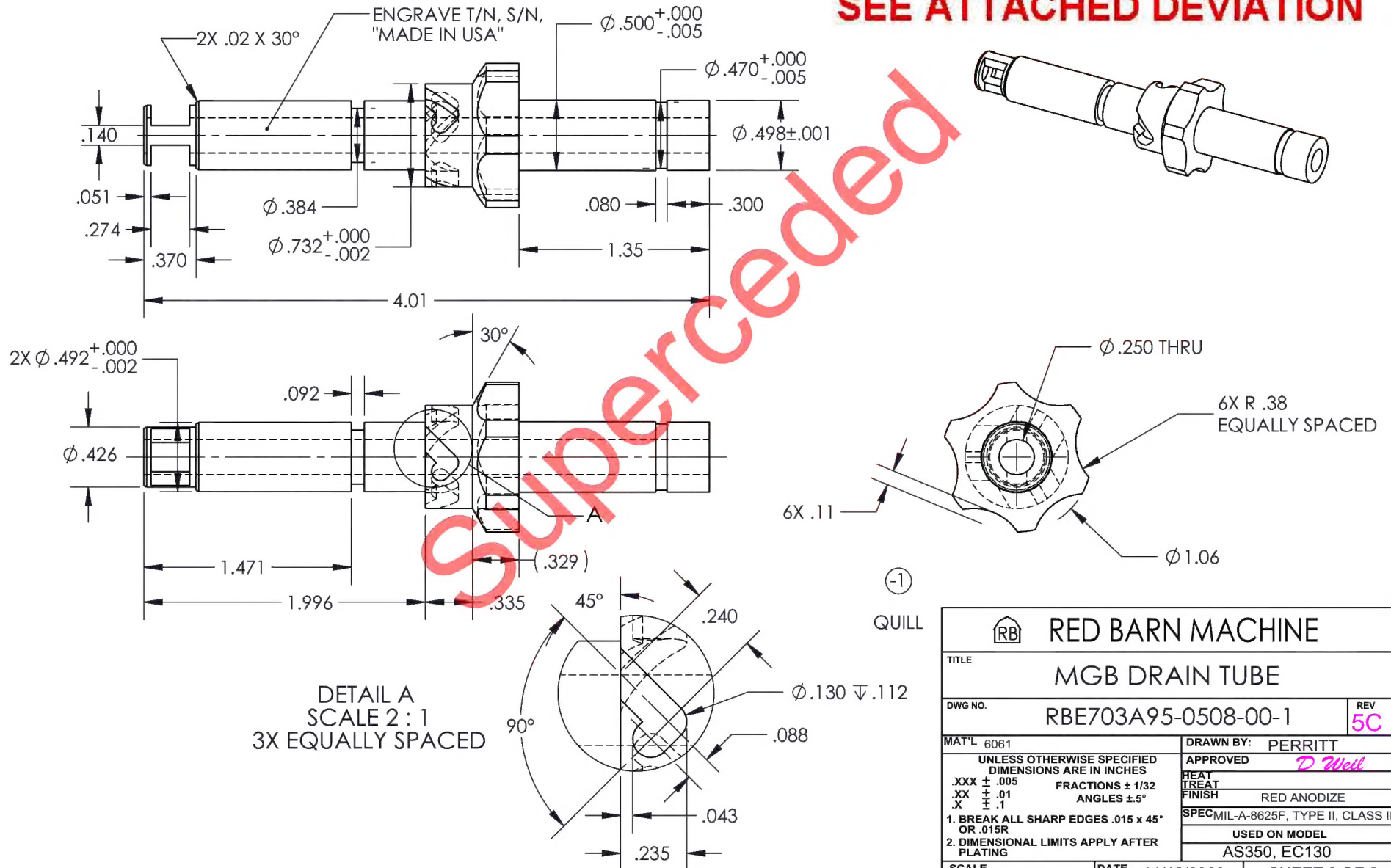
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UNDER REVIEW

URF 19-561 19.02.05 (KPT)

REVISIONS				
REV	DESCRIPTION	DATE	INITIAL	APPROVED
1	CH'D O-RING FROM $\phi 13\text{mm}$ OD x 1.75mm cross section. ADDED NOTES, CH'D SLOTS FROM 90° @ $\phi .131$, AND ID FROM $\phi .230$	5/28/2009	WP	RW
2	CH'D ID FROM $\phi .256$ THRU, CH'D SLOTS FROM 60° @ $\phi .125$ ON HELIX PER G.E.	11/4/2009	RJC	RW
2A	DELETED 20.2" REF. DIMENSION PER G.E.	12/16/2010	RJC	RW
3	CH'D STEM LENGHT FROM .800 TO 1.35, DELETED BARB, ADDED GROOVE	7/31/2012	JAG	
4	CH'D 8X R.156 & 8X .12 TO 6X R.375 & 6X .106.	4/17/2013	CFS	GE
5	1 CH'D DIMS WAS 6X .106 IS 6X .11, WAS 6X R .375 IS 6X R .38.	6/19/2013	BIM	RW

SEE ATTACHED DEVIATION



RED BARN MACHINE	
TITLE MGB DRAIN TUBE	
DWG NO. RBE703A95-0508-00-1	REV 5C
MAT'L 6061	DRAWN BY: PERRITT
UNLESS OTHERWISE SPECIFIED DIMENSIONS ARE IN INCHES	APPROVED <i>D Weil</i>
.XXX $\pm .005$	HEAT TREAT
.XX $\pm .01$	FINISH RED ANODIZE
.X $\pm .1$	SPEC MIL-A-8625F, TYPE II, CLASS I
1. BREAK ALL SHARP EDGES .015 x 45° OR .015R	USED ON MODEL
2. DIMENSIONAL LIMITS APPLY AFTER PLATING	AS350, EC130
SCALE 1:1	DATE 11/12/2008
SHEET 2 OF 2	

Entered: _____ Date: _____



WORK ORDER NON-CONFORMANCE / ROUTE UPDATE

NCR No. _____

Route update only ☐

Job: _____ Part No. <u>RBE703A95-0508-00 Rev. 5c</u>	DISPOSITION Rework <input type="checkbox"/> Scrap <input type="checkbox"/> Use-as-is <input type="checkbox"/>	DEPARTMENT/PROCESS <div style="display: flex; justify-content: space-between;"> <div> Skid-tube <input type="checkbox"/> Machining <input type="checkbox"/> Large Fab <input type="checkbox"/> </div> <div> Cross tube <input type="checkbox"/> Small Fab <input type="checkbox"/> Finishing <input type="checkbox"/> </div> <div> Eng. (Non-AW) <input type="checkbox"/> Prod. Eng. Coord. <input type="checkbox"/> Rec/Store/Packaging <input type="checkbox"/> </div> <div> Engineering <input type="checkbox"/> Water Jet <input type="checkbox"/> Supplier Quality <input type="checkbox"/> </div> </div>		
Date : _____	Sequence #: _____	QTY Affected : _____	MRB (QSI042) Oct 30, 2018	
Description Work Order Deviation		Disposition		Completed By
Kuri-Tech Hose (K010-0608) easily pulls out of Coupling (McMaster Carr 51495K116)		Install a 1.0" long, 0.38" OD, 0.25" ID piece of Stainless Steel into one end of the Kuri-Tech Hose until flush. Attach the modified end of the Kuri-Tech Hose to the Coupling before placing tool into packaging (if applicable). This deviation is acceptable. The fit, form and function of the part will be as originally intended.		Lead hand / Supervisor
				QC / QA Coordinator
Root Cause		FAULT CATEGORY		
<div style="display: flex; flex-direction: column;"> <div>Operator <input type="checkbox"/></div> <div>Manufacturing Process <input type="checkbox"/></div> <div>Equip/Tooling <input type="checkbox"/></div> <div>Handling/Presservation <input type="checkbox"/></div> <div>Material <input type="checkbox"/></div> <div>Product Improvement <input checked="" type="checkbox"/></div> <div>Process Improvement <input type="checkbox"/></div> <div>Human Factors <input type="checkbox"/></div> </div>		<div style="display: flex; flex-wrap: wrap;"> <div style="width: 50%;"> <input type="checkbox"/> Pressure/Forced <input type="checkbox"/> Bending <input type="checkbox"/> Crushing <input type="checkbox"/> Cracks <input type="checkbox"/> Crimp/Kink/Ripple/Wave/Twist <input type="checkbox"/> Marks/Chatter <input type="checkbox"/> Mislabeled </div> <div style="width: 50%;"> <input type="checkbox"/> Contamination <input type="checkbox"/> Misaligned/off center <input type="checkbox"/> BOM/Route <input type="checkbox"/> Broken/Damage/Defect <input type="checkbox"/> Incomplete/Unclear Instructions <input type="checkbox"/> Drill Holes <input type="checkbox"/> Fit/Function </div> <div style="width: 50%;"> <input type="checkbox"/> Power Loss/Surge <input type="checkbox"/> Folio/Program <input type="checkbox"/> Grain Direction <input type="checkbox"/> Weld <input type="checkbox"/> Wrong Stock Pulled <input type="checkbox"/> Out of Sequence <input type="checkbox"/> Off-set/Set-up </div> <div style="width: 50%;"> <input type="checkbox"/> Positioned Wrong <input type="checkbox"/> Outside Tolerance <input type="checkbox"/> Drawing <input type="checkbox"/> Finish <input type="checkbox"/> Part Lost/Missing <input type="checkbox"/> Misread </div> </div>		
Other/Details: _____				

URF 19-561 19.02.05 (KPT)

UNDER REVIEW